

Work Order ID 66430

February 14, 2011 1:07:57 PM



Page 1

Item ID:	D3140-105	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	2/14/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/18/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>11/02/14</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3140	<input type="checkbox"/> Dwg Rev:	<u>F</u>	<input type="checkbox"/> Prog Rev:	<u>F</u>	<input type="checkbox"/> 2-			
<u>2004 .030</u>	Deburr if necessary								

B 11-2-16

D

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

FB 11-2-16

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Sulod 16

AD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66430

Page 2

February 14, 2011 1:07:57 PM

Item ID: D3140-105

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 2/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
	Memo	0.00							
	1-Deburr if necessary								
140 Brake NC	NC BRAKE	0.00							
	Memo	0.00							
	Form as per Dwg D3140								
150 Small Fab	Small Fab	0.00							
	Memo	0.00							
	1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges								

N/A

Ss 11/02/17

Ss 11/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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February 14, 2011 1:07:57 PM



Page 3

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 2/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 11-02-17

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

RT 11-02-17 (X1)

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Sublot

(40)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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February 14, 2011 1:07:57 PM



Page 4

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Revision ID:

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Item Name: Doubler

Start Date: 2/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: *composite*

0.00



Packaging

Memo

0.00

Packaging

BT 11-02-17 (K1)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/02/17**11-02-17*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February 14, 2011 1:07:56 PM

Page 1

Work Order ID: 66430



Parent Item: D3140-105



Parent Item Name: Doubler

Start Date: 2/14/11

Required Date: 2/18/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-08 JLM
IPP Rev B ☐ New dwg rev. ecn781 06.04.18 EC
IPP rev.C added scuffing NCR 061 EC
IPP Rev:D As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	64.7832	0.055	0.057895			
2024-T3 .032 sheet													

Location

Loc Qty

Loc Code

MAT22

64.783158

105555

3

111699

4

113189

57.783158

111699

11-2-16

①

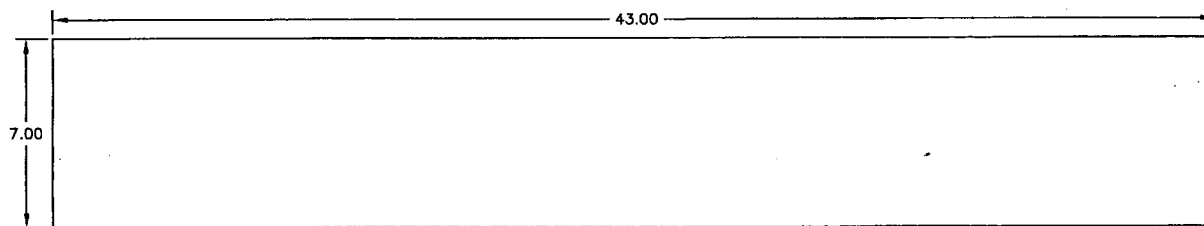
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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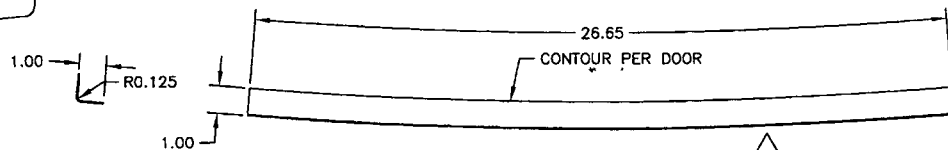
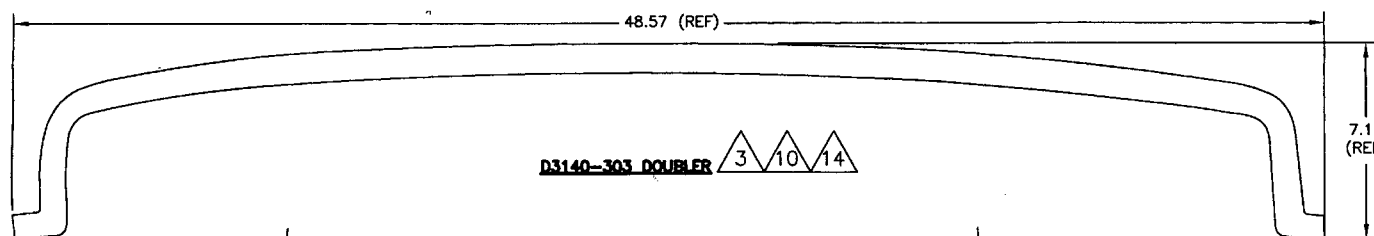
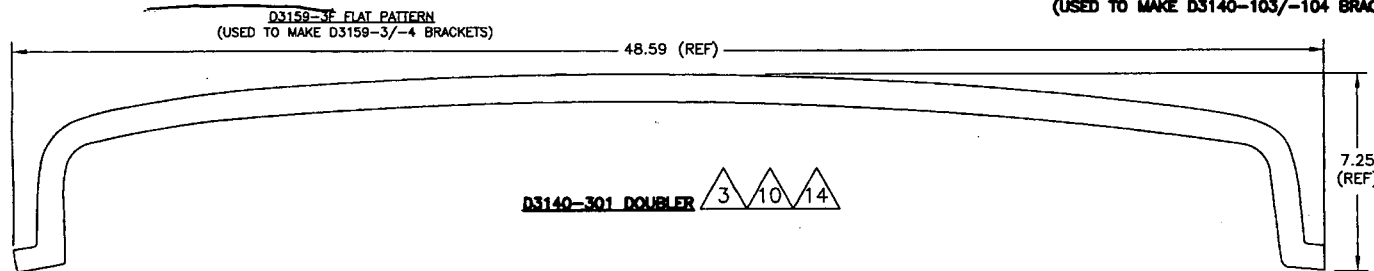
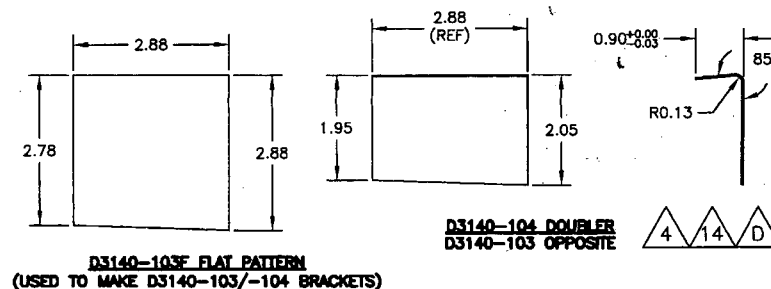
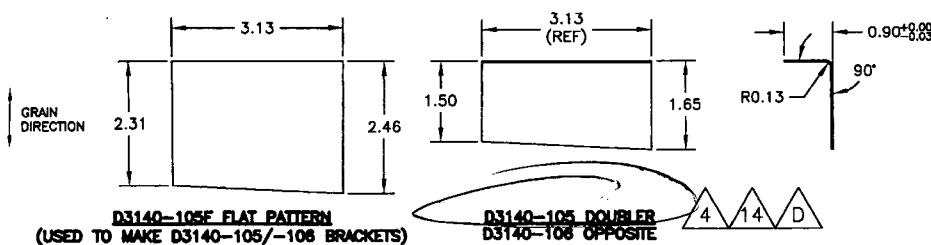
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NOTE: Date & initial all entries



D3140-87 DOUBLER $\triangle 4 \triangle 14$
(REPLACES PREMIER P/N B30-23000-87)



RELEASED

06.11.13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 666430
C211/02/14

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		DATE	06.10.06	TITLE		DOOR	REV. F SHEET 6 OF 7
						SCALE	NTS

W/O:		WORK ORDER CHANGES					
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